

Date:
Use:Monday, 1/23/2006 7:51:40 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT X-TUBE EXT HEIGHT GEAR
Job Number	: 25582		
Estimate Number	: 10421		
P.O. Number	: N/A	Part Number	: D205596103
This Issue	: 1/23/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D205-596-103 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 23805	Drawing Revision	: A
		Material	: N/A
Written By	: _____	Due Date	: 2/15/2006
Checked & Approved By	: _____	Qty:	1 Um: Each
Comment	: Est Rev:G 05.06.10 Acid etch moved to Step 11 KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-103CHG001

See attached.

2.0

D2890

Aft Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube

B28491A DP 6-9-19

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Mark 30.21" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

DP 6-9-19

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions. Conformity check and sign off by engineering.

E 06.09.19

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-103

DP 6-9-19

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

DP 6-9-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/23/2006 7:51:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 25582

Part Number: D205596103

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EC 06.09.20

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



MI 06.09.20



(1)

Comment: HAND FINISHING RESOURCE #1

TOUCH UP Chemical Conversion Coat as per QSI 005 4.1

8.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

MI 06.09.20

(1)

9.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

EC 06.09.21 (1)

10.0 D2856600 Abrasion Strip



Comment: Qty.: 21.1890 f(s)/Unit Total: 21.1890 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(10.090")

Abrasion Strip

1.68
524328

11.0 D29401 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2940-1

Support

025594

12.0 MS2192028 Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-28

Clamp

MI 0604-3 / MI 00419-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/09/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/23/2006 7:51:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 25582

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg
D205-596-103. Torque clamps to 80-100 in lb.

2T 06-09-21

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ND 6-9-21

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-103

Location: -

Rev 1-

6/9/22

①

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.09.22

Job Completion



U 06.09.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

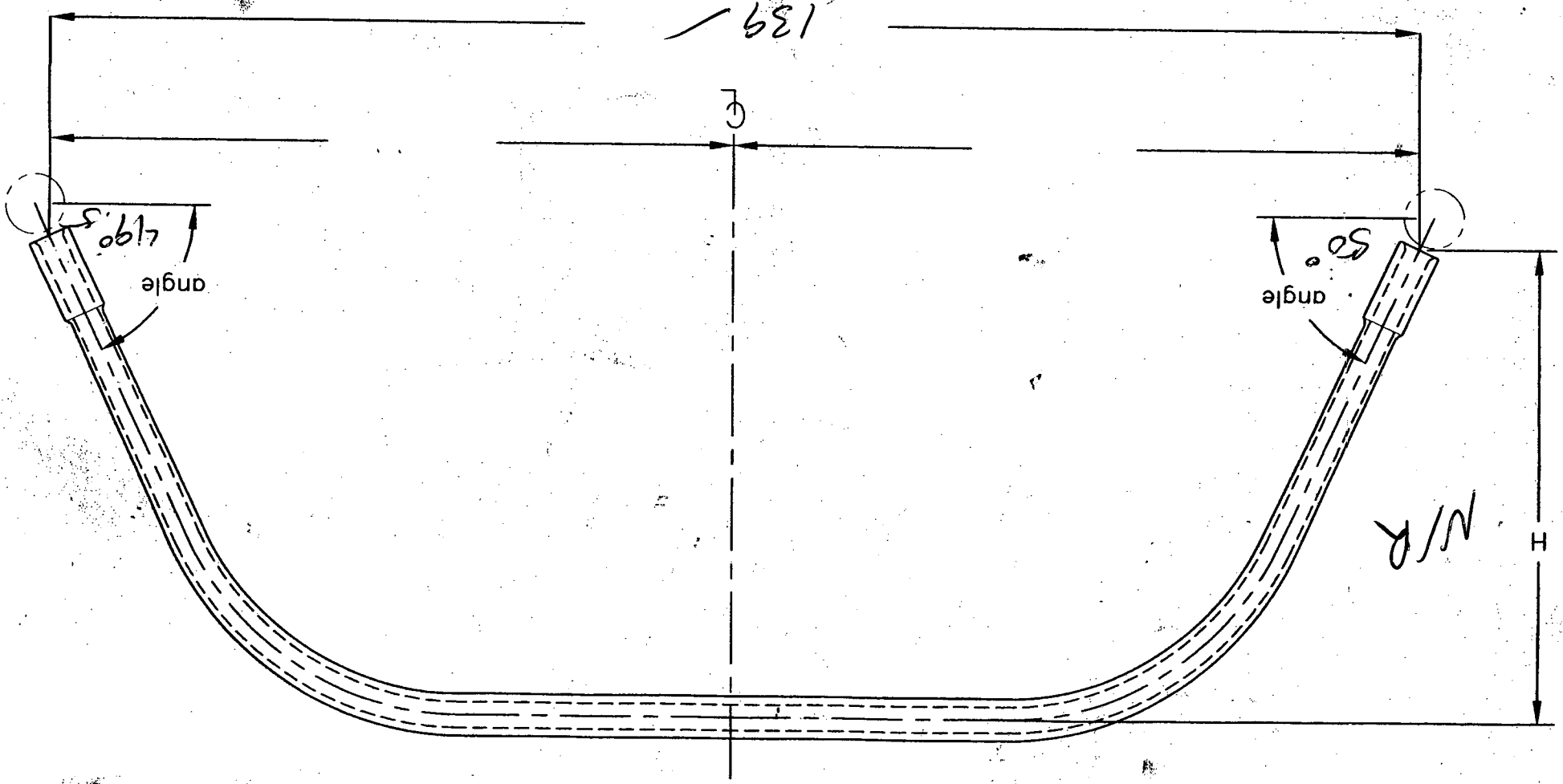
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DATE: 06.09.13
 DESCRIPTION: D 2890
 BATCH NO: B28491A
~~DRAWING: 0305 S/L 103 2890~~
 H: 50.0
 1/2 SPAN: N/A
 TOTAL SPAN: 138.8 ± .25
 ANGLE: 50° ± 2

06.09.13
 To mtlu - 103



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Process Sheet

7

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 Job Number : 25582
 Estimate Number : 10421
 P.O. Number :
 This Issue : 1/23/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D205596103
 First Issue : / / Type : LANDING GEAR Drawing Number : D205-596-103 REV A
 Previous Run : 23805 Project Number : N/A
 Material :
 Written By : Due Date : 2/15/2006 Qty: 1 Um: Each
 Checked & Approved By :
 Comment : Est Rev:G 05.06.10 Acid etch moved to Step 11 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-103CHG001

06.02.27

2.0 D2890 Aft Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

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4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions. Conformity check and sign off by engineering.

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-103

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

REFERENCE ONLY